



Dart Hawkesbury
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D4635-143

Job Sheet 167106-J



Part No: D4635-143 **REV. F 10** Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Small Fab	<i>D.M.L 18-3-27</i>
100	Small Fab	1 pcs		11/9/17	0.00	0.68	Small Fab	<i>D.M.L 18-3-27</i>
110	Small Fab	1 pcs		11/10/17	0.00	0.68	Small Fab	<i>D.M.L 18-3-27</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>OK</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>D.M.L 18-3-27</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>21</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-3 <i>305553</i>	1	2	0	0
	D4669-1 <i>5009911</i>	1	27	0	0
	D4669-3 <i>F11 2668</i>	1	38	0	0
	D4695-3 <i>5019450</i>	1	5	0	0
	D4732-1 <i>5008984</i>	1	6	0	0
	D4732-13 <i>F123206</i>	1	6	0	0
	D4732-37 <i>5009004</i>	1	3	0	0
	D5022-3 <i>5017752</i>	1	1	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																								
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				QC / QA Coordinator Approval																																								
DART Aerospace Ltd. 1270 Aberdeen Street Newmarket, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S055162 Part: D4635-143 Job No: 167106-J Serial No/Batch: S055162 Revision: F Inspector: Date: 03/27/18																																												
Environ: _____ Doc: _____ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border: none;"> <tr> <td style="border: none;">Cracks</td> <td style="border: none;">Inspection Incomplete, _____ified</td> <td style="border: none;">Power Loss/Surge ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Crimp/Kink/Ripple/Wave</td> <td style="border: none;">Contamination</td> <td style="border: none;">Folio/Program ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Cuffs</td> <td style="border: none;">Countersink</td> <td style="border: none;">Grain ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Crushing</td> <td style="border: none;">Cut Too Short</td> <td style="border: none;">Weld ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Heat Treat</td> <td style="border: none;">Instructions Incomplete/Unclear</td> <td style="border: none;">Wrong Stock Pulled ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube</td> <td style="border: none;">Drill Holes</td> <td style="border: none;">Out of Sequence ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter</td> <td></td> <td style="border: none;">Off-set ☐</td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Mislabeled ☐</td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Fit/Function ☐</td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Misaligned/off center ☐</td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>			Cracks	Inspection Incomplete, _____ified	Power Loss/Surge ☐	Positioned Wrong ☐	Crimp/Kink/Ripple/Wave	Contamination	Folio/Program ☐	Outside Dimensions ☐	Cuffs	Countersink	Grain ☐	Over/Under tolerance ☐	Crushing	Cut Too Short	Weld ☐	Part Incorrect ☐	Heat Treat	Instructions Incomplete/Unclear	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Wave/Twist in Tube	Drill Holes	Out of Sequence ☐	Part Moved ☐	Marks/Chatter		Off-set ☐	Drawing ☐			Mislabeled ☐	Finish ☐			Fit/Function ☐	Misread ☐			Misaligned/off center ☐	Turning Sequence ☐
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